

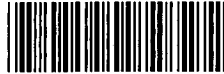
Date: Monday, 06/10/2008 1:21:08 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RIGHT ARM WELDMENT
Job Number	: 42477		
Estimate Number	: 12104		
P.O. Number	:	Part Number	: D3354043
This Issue	: 06/10/2008 S.O. No. :	Drawing Number	: D3354 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 36639	Material	:
Written By	:	Due Date	: 24/10/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>JUL 08.10.06</u>		
Comment	: est rev A 06.01.25 new issue EC est rev B 07.05.14 rev B dwg Ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33543	Wheel Shaft
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 pick:

qty	part number	description	batch
1	D3354-3	shaft	B36232 *

*Plc 08.10.21*

2.0	D33545	Right Arm Plate
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 pick:

qty	part number	description	batch
1	D3354-5	right arm	B34634 → 4 B42496 → 2

*Plc 08.10.21*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354

2-Grind welds flush as per dwg D3354

*Plc 08.10.21*

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

*BE 08-10-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 06/10/2008 1:21:09 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 42477

Part Number: D3354043

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/21 (x6)

6.0

POWDER COATING

POWDER COATING



M18052



Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

8:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:00am

JP 08-10-23 (x6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/10/23

(x6) SP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: U88

8/10/23

SP  
6K

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/31 (x6)

Job Completion



MF 08-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

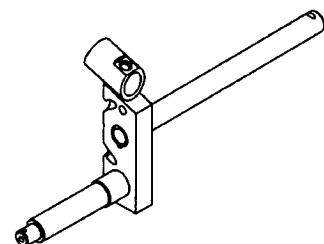
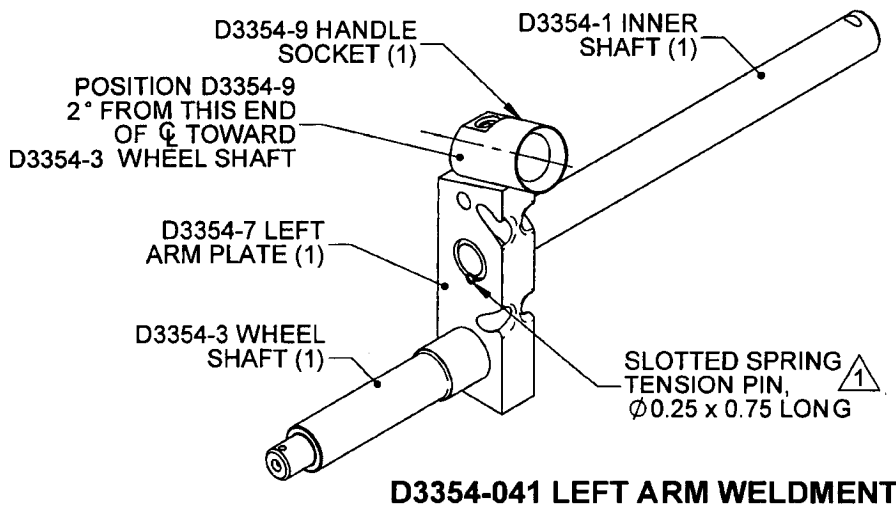
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

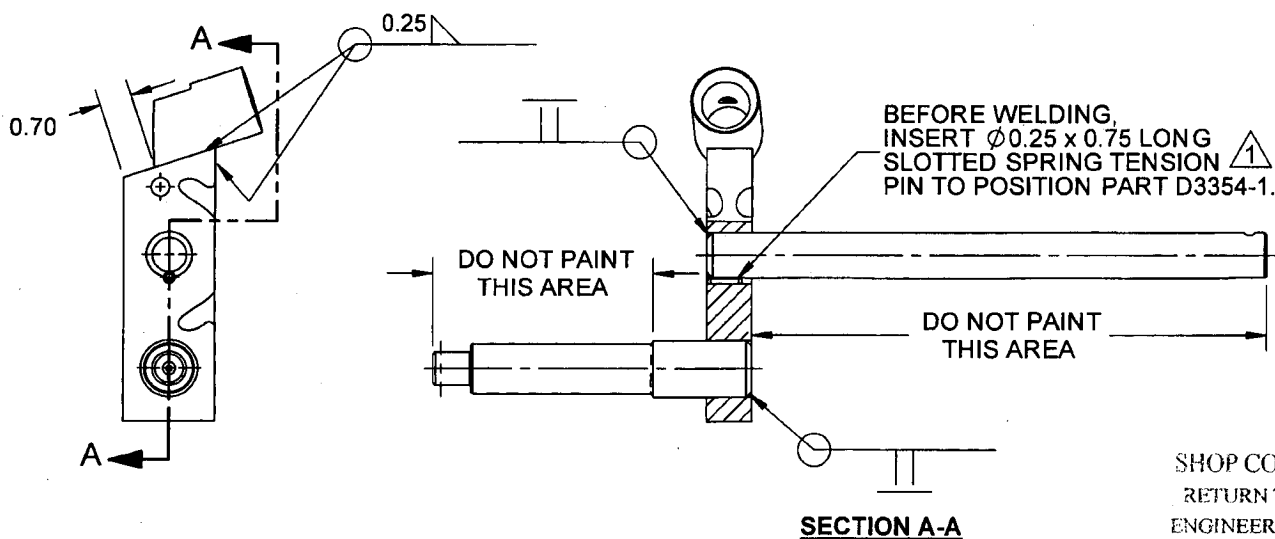


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CHECKED <i>lb</i>	APPROVED <i>MP</i>	DRAWING NO. <b>LEFT ARM WELDMENT</b>	REV. C SHEET 1 OF 7
DATE <b>07.12.06</b>		TITLE <b>D3354</b>	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	
C	07.12.06	CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT	

RELEASED  
07/12/07 *MP*



**D3354-042 MIRROR ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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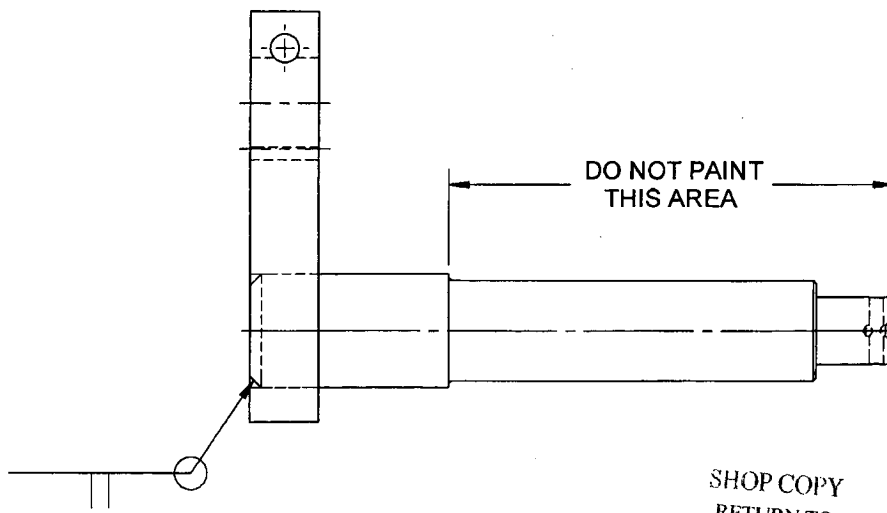
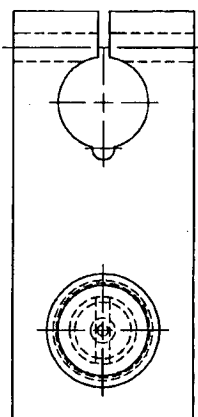
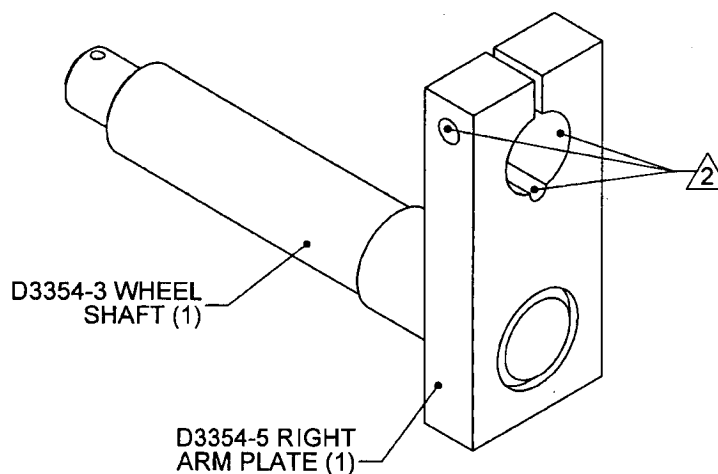
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED  
01/12/07 *MP*



### D3354-043 RIGHT ARM WELDMENT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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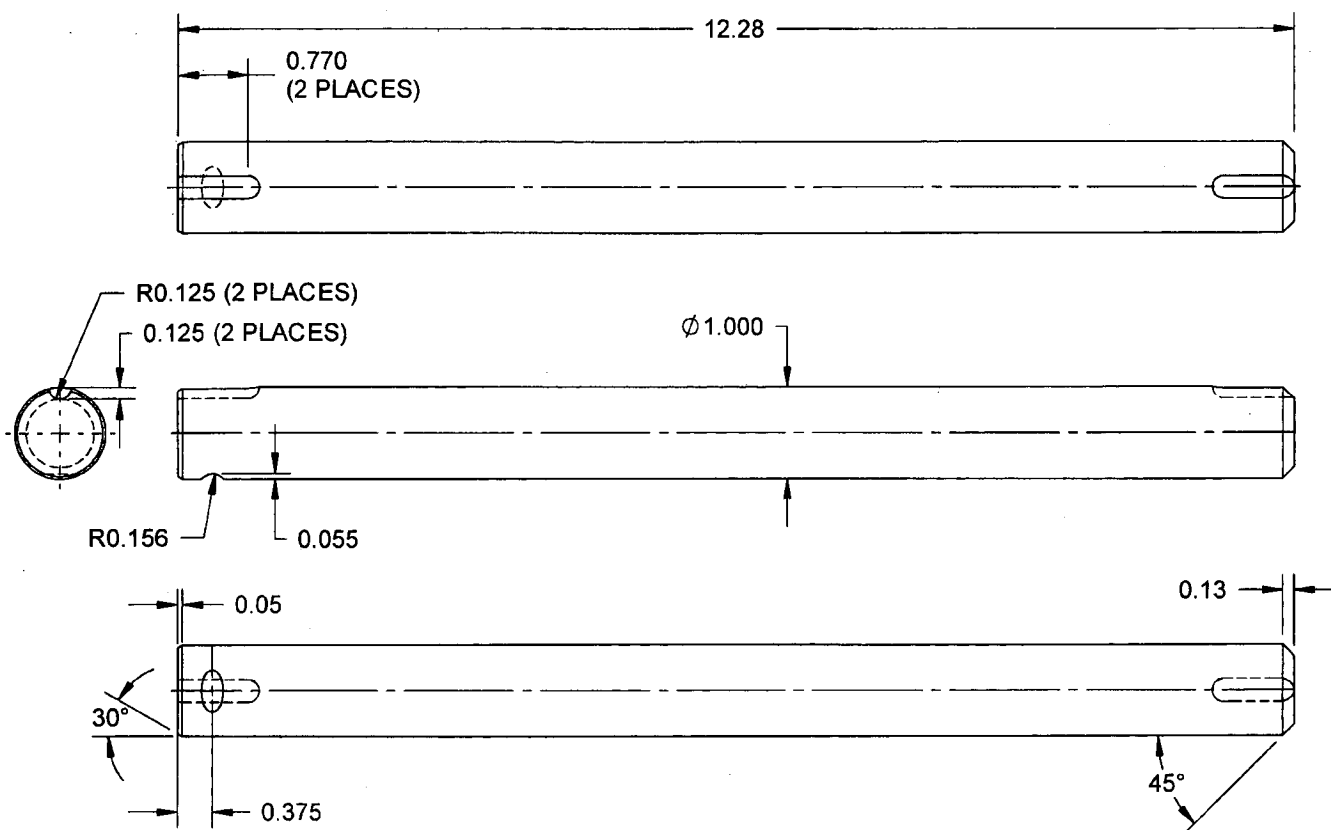
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

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*01/12/07*



**D3354-1 INNER SHAFT**

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NO. *42477*

**NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91  
OR UNS#-G41400 ROUND BAR,  $\phi$ 1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

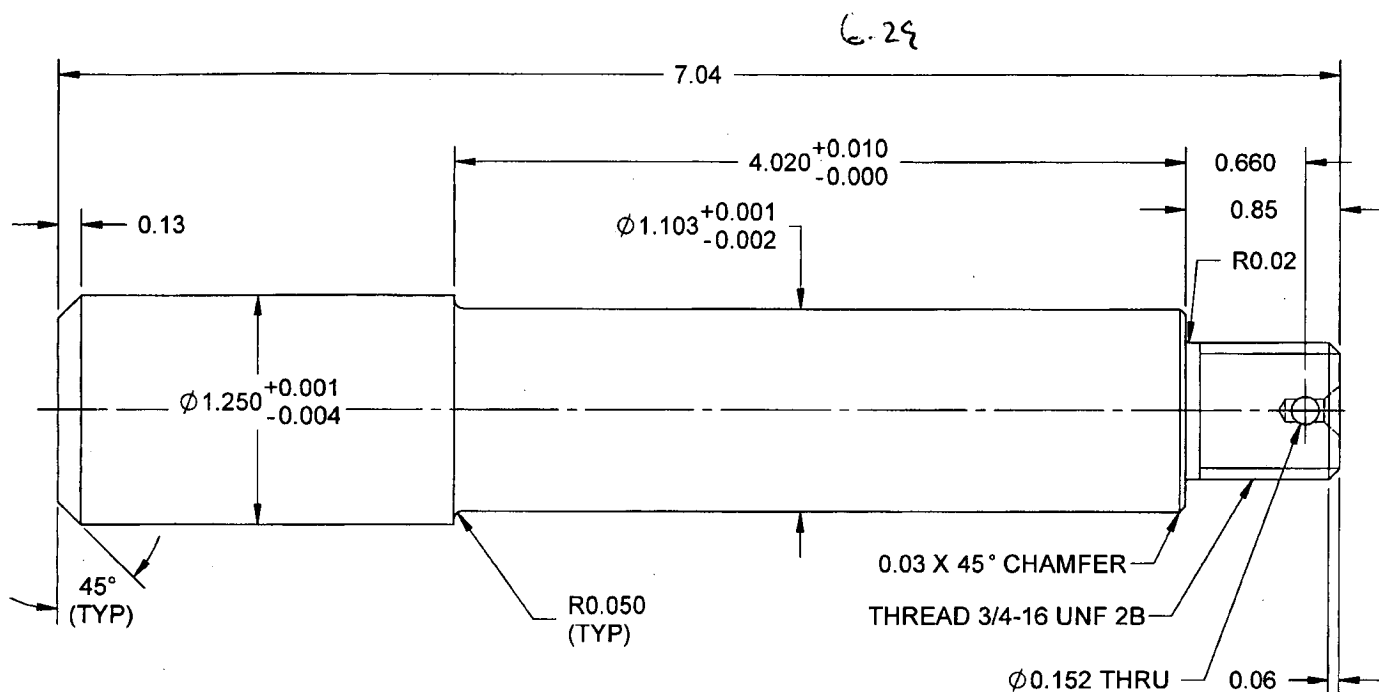
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1

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07.12.07 *[Signature]*



### D3354-3 WHEEL SHAFT

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#### NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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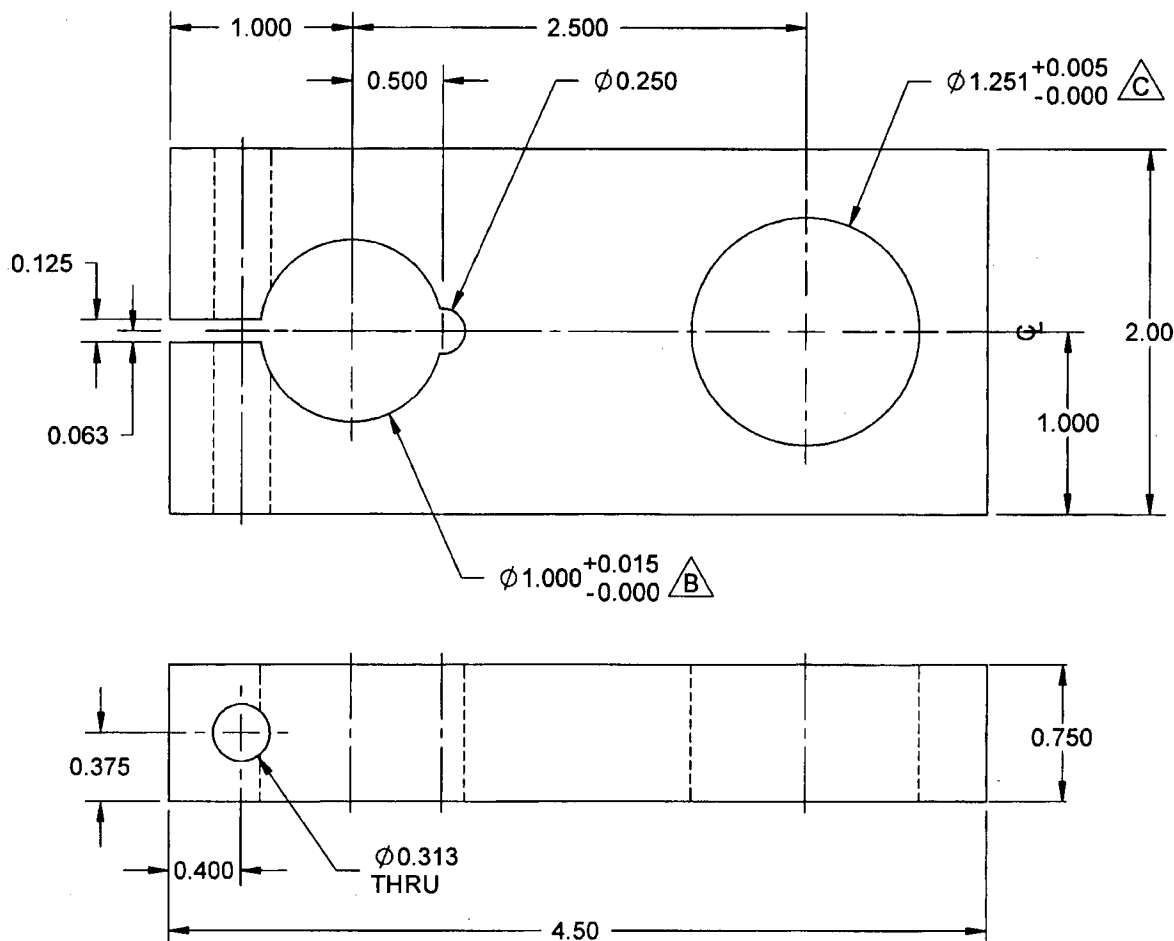
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1

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### D3354-5 RIGHT ARM PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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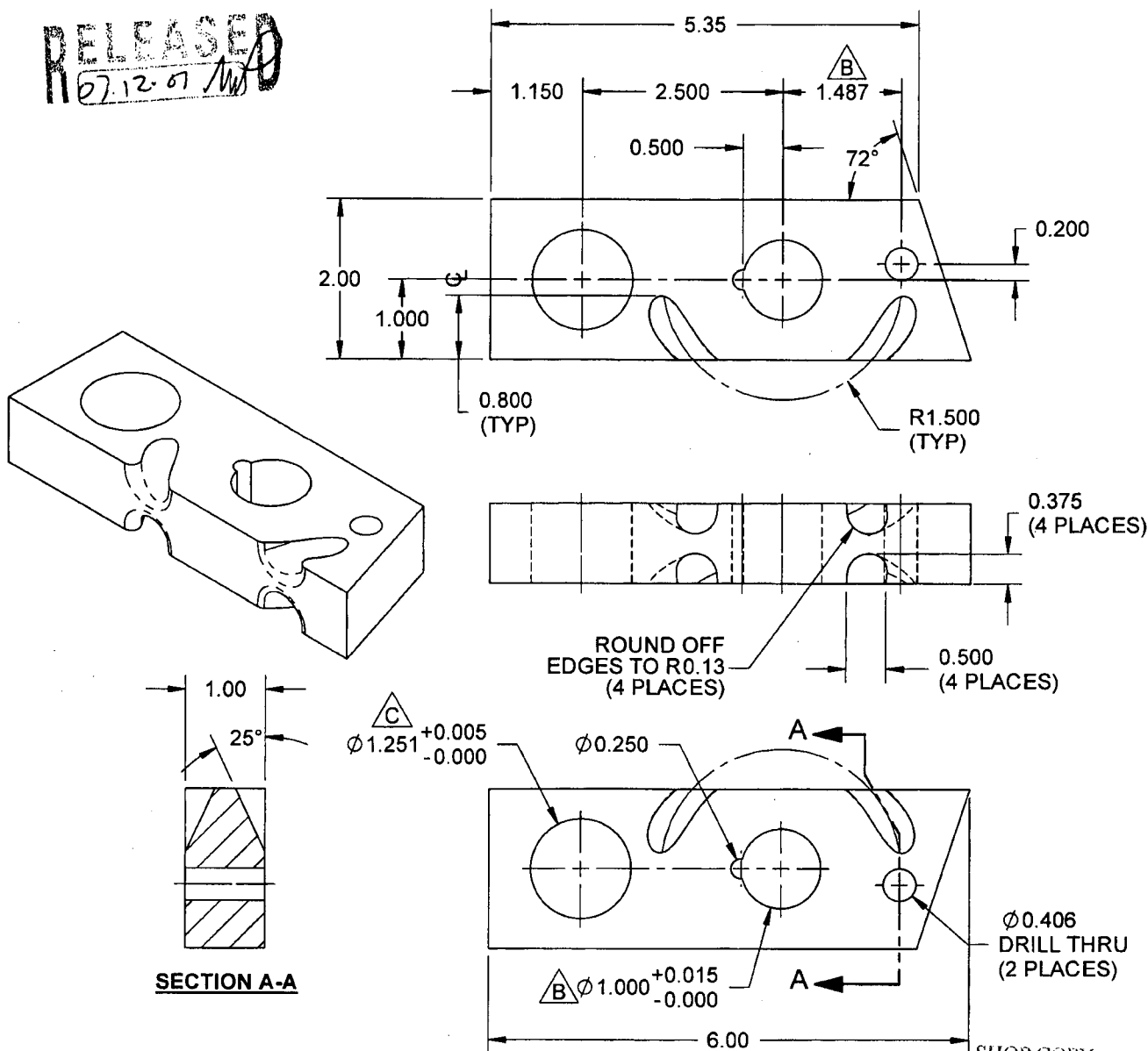
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DATE <b>07.12.06</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

RELEASED  
07.12.07 *MM*

**D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD NO. 42477 STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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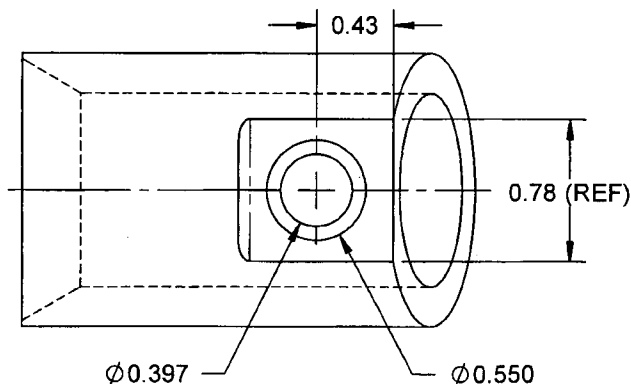
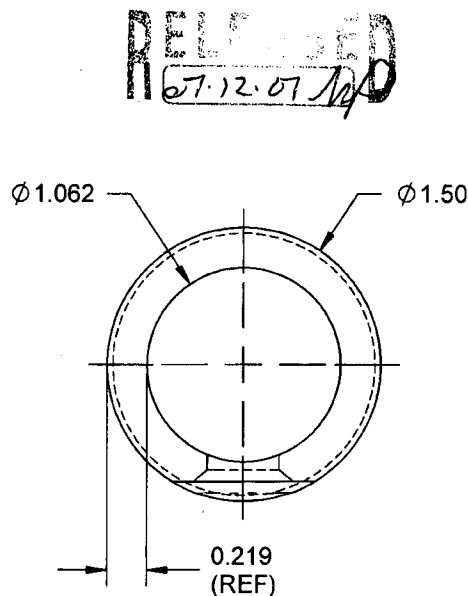
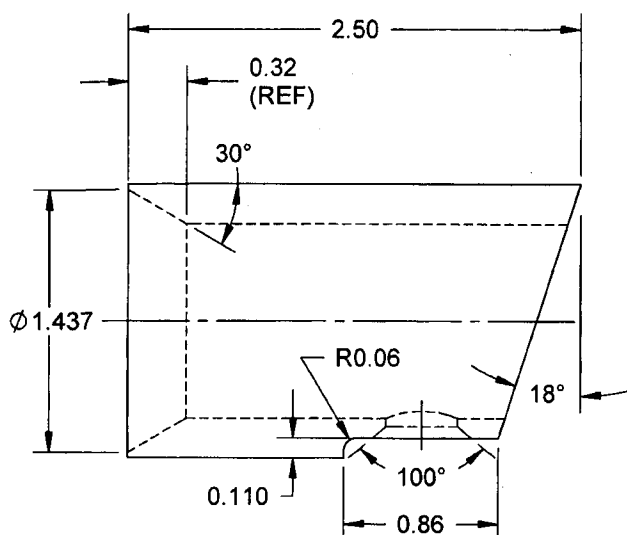
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1



### D3354-9 HANDLE SOCKET

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAM LESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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